

Work Order ID 62143

Thursday, September 16, 2010 3:37:12 PM



Page 1

Item ID: D4132-042

Accept



Setup Start



Revision ID:

Item Name: Wearplate, RH Fwd

Stop



Start Date: 9/16/2010 Start Qty: 2.00

Required Date: 9/23/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: MF

Date: 10-9-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4132	pb1

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut D4132-1F as per Dwg D4132

Dwg Rev: pb1

Prog Rev: pb1

2-Deburr if necessary

0.00

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAHFAIB

Memo

0.00

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Give to Dan Stow before forming

ENGINEERING
APPROVAL

HB 10-9-20

HB 10-9-20

AP 10-09-20

②

RTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	AP QC In

Part No: D4132-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>62143</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.10.06	100	Design changed. PARTS NO LONGER CORRECT	W 10/10/07 D4132	SCRAP 10.10.06 NEW PARTS MADE TO REV. B	W 10.10.06	S 10/10/07	W 10-10-07 D4132	B 10.10.07

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/23/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Form as per dwg
NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

1- Form using DT _____ Die as per Dwg D4132

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

**ENGINEERING
APPROVAL**

150

Weld per dwg A/R Hardcoat S.S. Batch: _____
Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

Weld hard surface using DT _____ as per QSI 004 and Dwg D4132_

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Start Date: 9/16/2010 Start Qty: 2.00

Required Date: 9/23/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

**ENGINEERING
APPROVAL**

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

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Revision ID:

Stop

Item Name: Wearplate, RH Fwd

Start Date: 9/16/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 9/23/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond D4132-3 gasket to inner surface of wearplate using a thin layer of 3M
1300/1300L scotch grip adhesive
Batch: _____

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Work Order ID 62143

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Item ID: D4132-042

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Stop



Item Name: Wearplate, RH Fwd

Start Date: 9/16/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/23/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



Identify as per dwg & Stock Location: _____

0.00

Packaging

Packaging

Memo

0.00

Packaging

230



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 9/17 AUTH W

RELEASED _____ DATE _____

Picklist Print

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Page 1

Work Order ID: 62143

Parent Item: D4132-042

Parent Item Name: Wearplate, RH Fwd



Start Date: 9/16/2010

Required Date: 9/23/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4132-3  Gasket		Manufactured	No			200	Each	1.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				1					
					60303			1					
M304S18GA  304/316 .050 Sheet		Purchased	No			100	sf	155.0479	1.555	3.273684			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT20				155.0479					
				111743				7.36					
				112885				25.5179					
				113062				58.17					
				115389				64					

1810-9-20

②

112885

DART AEROSPACE LTD		Work Order: 62143
Description: WEARPLATE		Part Number: D4132-42
Inspection Dwg: D4132-2 Rev: pbl		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

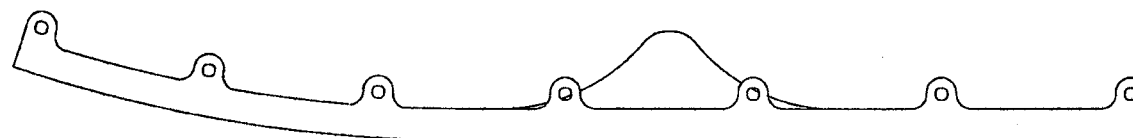
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 203	+0.005 - .001	.202	X			
.375	± .010	.376	X			
.490	± .010	.490	X			
2.89	± .030	2.877	X			
5.780	± .010	5.776	X			
5.77	± .030	5.770	X			
8.05	± .030	8.02				
1.92	± .030	1.920	X			
5.024	± .010	5.025	X			
9.824	± .010	9.824	X			
11.92	± .030	11.92	X			
14.548	± .010	14.548	X			
19.273	± .010	19.273	X			
21.92	± .030	21.92	X			
23.613	± .010	23.613	X			
27.953	± .010	27.953	X			
1.10	± .030	1.028	X			
4.37	± .030	4.538				
.300	± .010	.305	X			
.450	± .010	.458	X			
.050	± .010	.047	X			

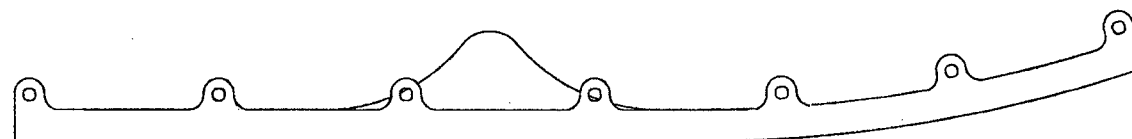
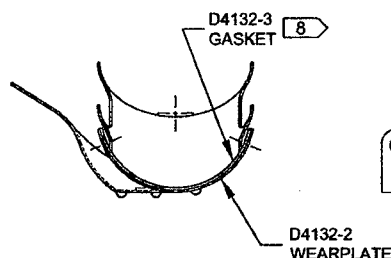
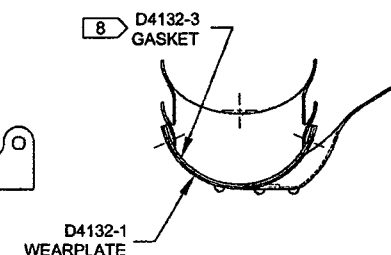
Measured by: RB	Audited by:	Prototype Approval:	N/A
Date: 10-9-20	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D4132-041	WEARPLATE, LH FWD
	X	D4132-042	WEARPLATE, RH FWD
1		D4132-1	WEARPLATE
	1	D4132-2	WEARPLATE
1	1	D4132-3	GASKET
A/R	A/R	1300 / 1300L	3M SCOTCH-GRIP ADHESIVE



D4132-041 WEARPLATE, LH FWD



D4132-042 WEARPLATE, RH FWD

PRELIMINARY ISSUE

10.09.15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4132-xxx" USING YELLOW PAINT MARKER ON INSIDE SURFACE
- 7) WEIGHT: -041/-042 = 2.1 lbs
- 8) BOND D4132-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

P/B	0.450 WAS 0.300	CP	10.09.15
A	NEW ISSUE	CP	10.06.15
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>Q</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>Q</i>		
CHECKED		DRAWING NO.	REV. <i>B</i>
MFG. APPR.		D4132	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE, FWD	NTS
DATE	10.09.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

